

SPLIT-2

Dart Aerospace Ltd.

Date: Monday, 11/19/2007 4:04:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 35862 -2	Part Number	: D3463042
Estimate Number	: 10777	Drawing Number	: D3463 REV.B
P.O. Number	:	Project Number	: N/A
This Issue	: 11/19/2007 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 12/8/2007
Previous Run	: 33705	Qty:	2 Um: EACH
Written By	:		
Checked & Approved By	: <u>11.11.20</u>		
Comment	: EST REV. A 05.11.18 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	238806	SS DOWEL PIN 1" LONG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	238-806	SS DOWEL PIN 1" LONG	H105037 → 4x
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2.0	D34533	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D3453-3	Clevis	B35880 → 2x
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			B35879 → 2x
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3.0	D34637	Drag Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3463-7	Drag Arm	B34851 → 2x
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4.0	D34631	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3463-1	Arm	B34850 → 2x
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			08/01/28
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35862

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-3

Step

B34120-2 → 2x

dy

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3463-5

Step Flat Pattern

B33808 → 4x

dy

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-5

Plug

B35879 → 2x

B35880 → 2x

dy

08/01/28

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

dy

08/01/29 (2x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

dy

08-01-29 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

dy

08/01/29

(42)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 106379

dy

08-01-30

(R.)

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35862

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m 106332



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

FL 08/01/30 @

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/01/31

(2x)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *205*

8/1/31

SP (2x)

(2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/02/01

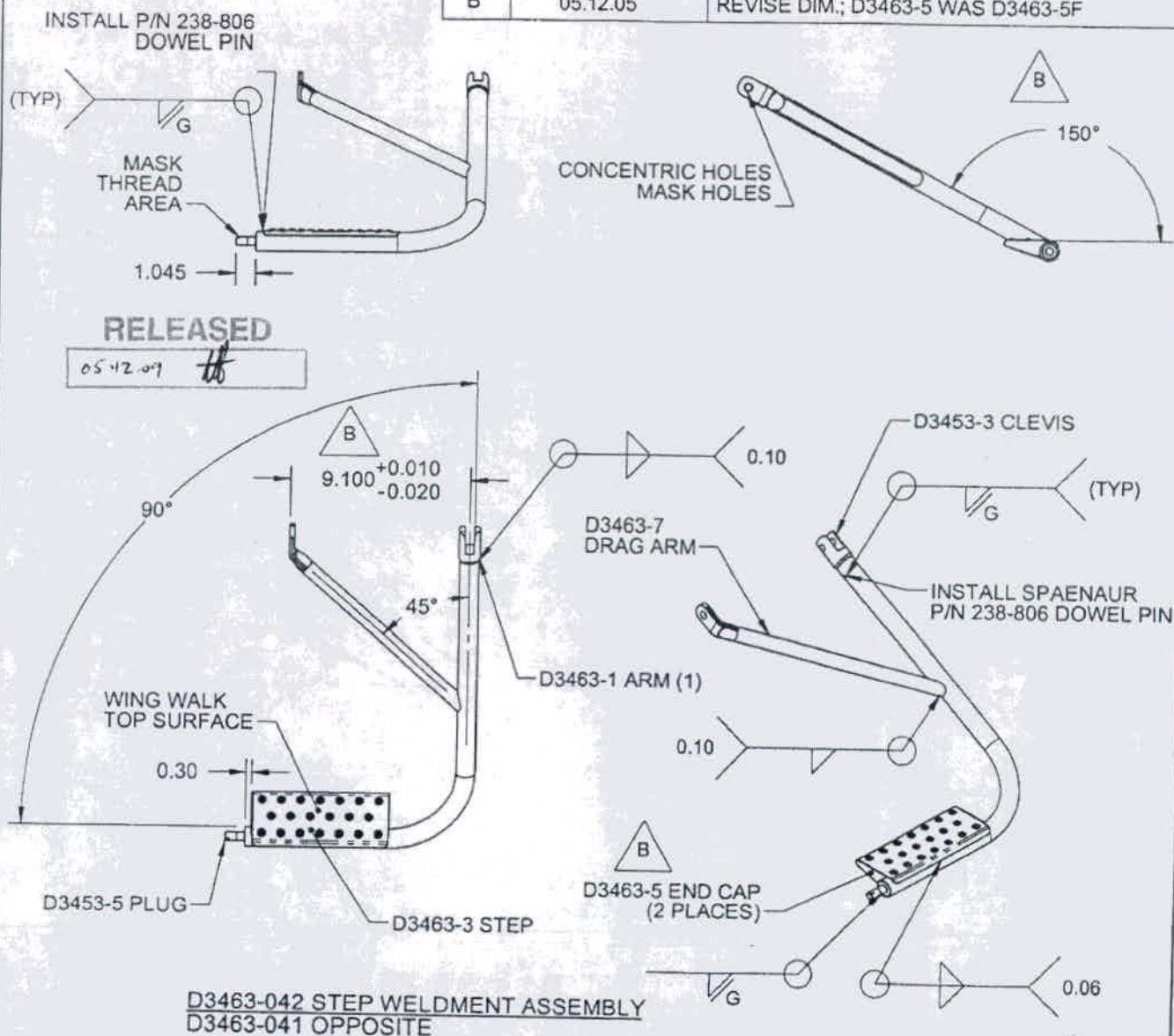
Job Completion



c208/01/31

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

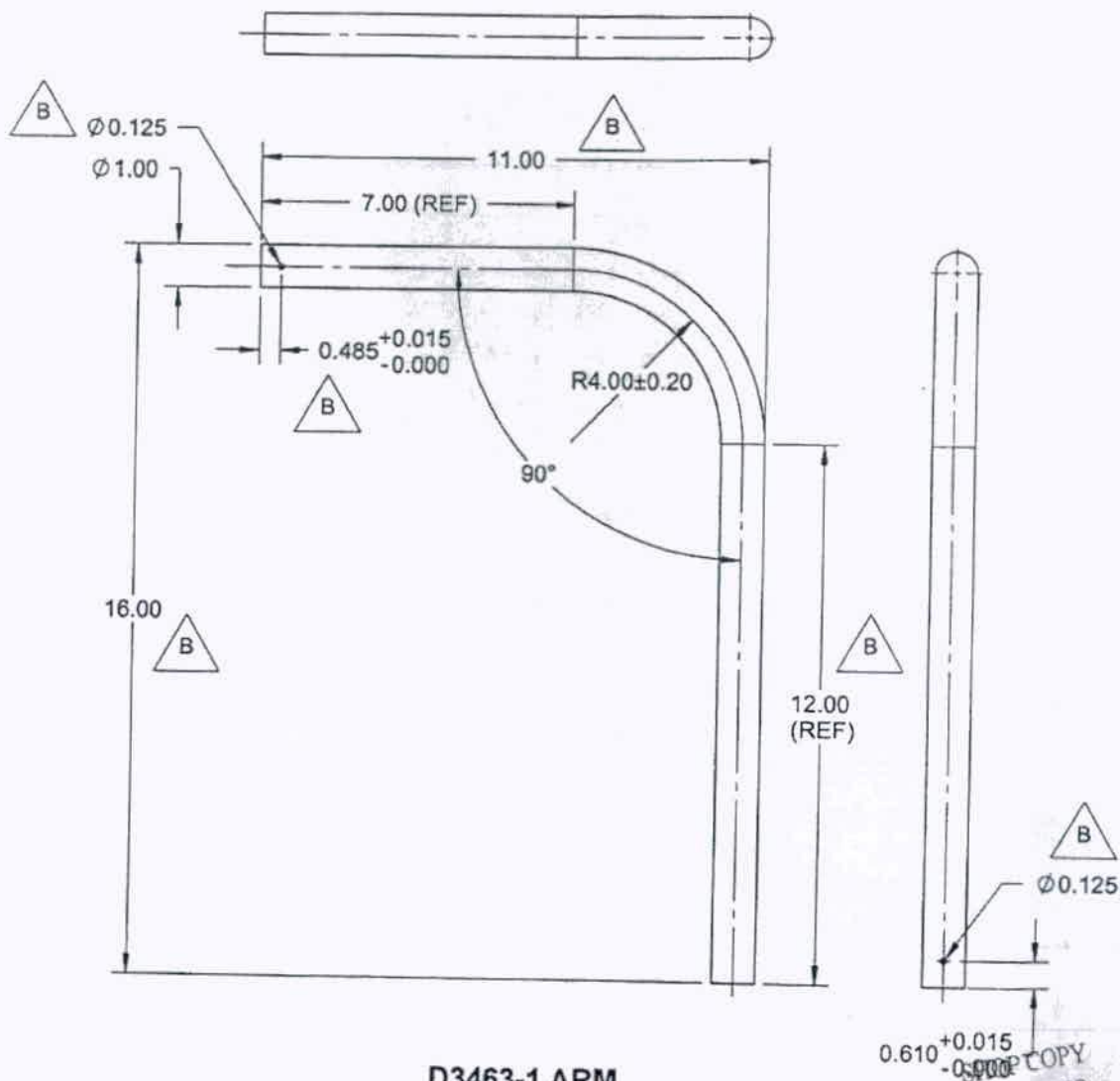
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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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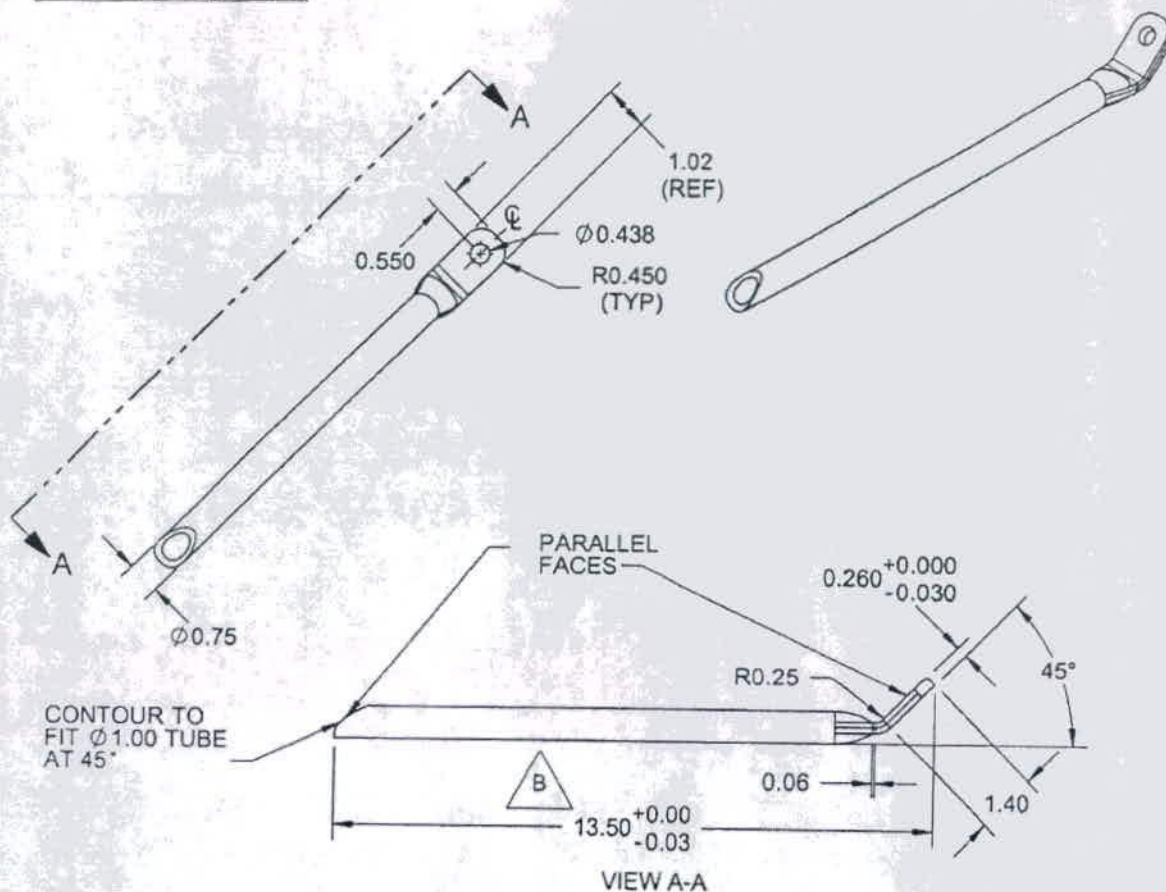
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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750X1.20)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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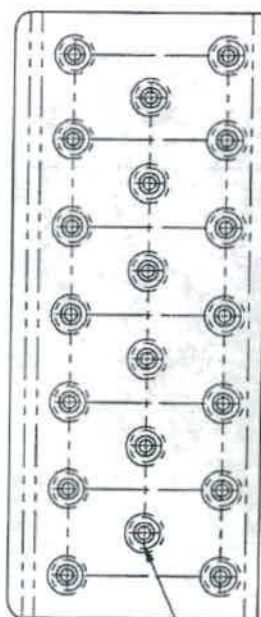
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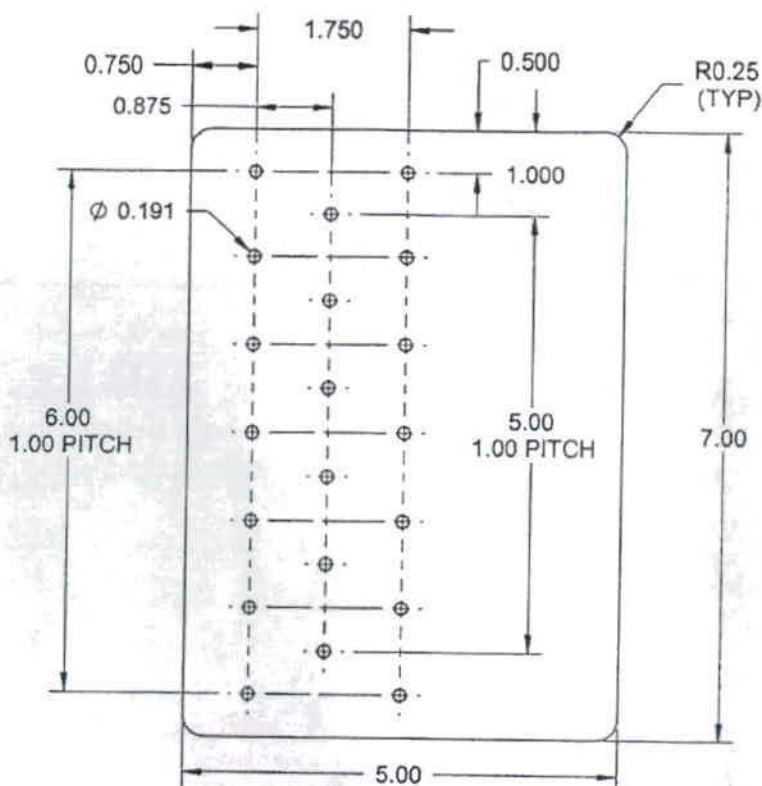
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DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

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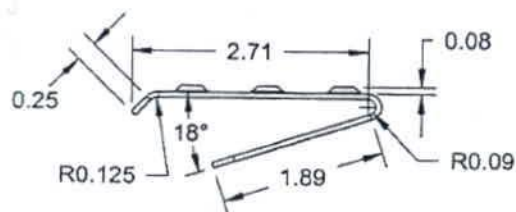
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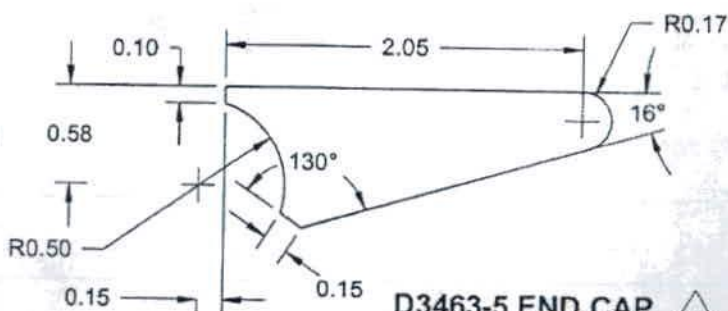
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP

SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

-5 END CAP
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